



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

6

D3391-025
Job Sheet 167283-E



Part No: D3391-025

Job Qty: 1 ea

Part Name: Aft Tube Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/27/17

Job Tracking No:

Due Date: 12/18/17

Created By: Victoria Michaud-Febrille

Type: SOLD

Description:

Customer: Falcon Aviation Services (CFALC01)

PO Box 62030 Abu Dhabi, United Arab Emirates ph:011 971 50 445 0187 fx:+971 2 444 0022.

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		12/15/17	0.00	0.00	Start Up Skid tubes		
100	Mori Seiki	1 pcs		12/15/17	2.49	4.17	Mori Seiki TL-40		PMP
110	QC	1 pcs		12/15/17	0.00	0.00	QC2		PMP
112	QC	1 pcs		12/15/17	0.00	0.00	QC5		AD 17-11-13
120	CNC Vertical Machining	1 pcs		12/16/17	0.00	2.63	HAAS 1		Kt 17-12-04
130	QC	1 pcs		12/16/17	0.00	0.00	QC2		Kt 17-12-04
140	QC	1 pcs		12/16/17	0.00	0.00	QC8		17/12/04
150	Skid tubes	1 pcs		12/16/17	0.00	1.03	Skid tubes		mcg
160	CNC Bend Skid tubes	1 pcs		12/16/17	0.00	1.33	CNC Bend Skid tube 4.275		mbh
170	QC	1 pcs		12/16/17	0.00	0.00	QC5		BE
180	Skid tubes	1 pcs		12/16/17	0.00	1.03	Skid tubes		mbh DAS
190	QC	1 pcs		12/16/17	0.00	0.00	QC5		38
200	HandFinish	1 pcs		12/16/17	0.00	0.58	HandFinish1		2017-12-19 / JS
210	QC	1 pcs		12/16/17	0.00	0.00	QC7		
220	Skid tubes	1 pcs		12/16/17	0.00	1.41	Skid tubes		AP 2017/12/20
230	QC	1 pcs		12/16/17	0.00	0.00	QC5		17-12-22
235	HandFinish	1 pcs		12/16/17	0.00	0.58	HandFinish2		2017-12-22 JS
240	Spray Paint	1 pcs		12/16/17	0.00	0.25	Spray Paint P0038670		17-12-22
250	QC	1 pcs		12/16/17	0.00	0.00	QC14		17-12-22
260	HandFinish	1 pcs		12/18/17	0.00	0.58	HandFinish4		17-12-22
270	QC	1 pcs		12/18/17	0.00	0.00	QC5		38
280	Packaging	1 pcs		12/18/17	0.00	0.00	Packaging3		9-88
290	QC21-SA	1 Ea		12/18/17	0.00	0.00	QC21		

Part Op 100 - Turn as per Folio FA599 Rev: AA & Dwg D3391 Rev: J ***ensure steady rest is turning true*** *****REMOVE
Descriptions: STEADY REST AND MACHINIG MARKS****

120 - 1-Machine as per Folio FA 599 Rev: AA & Dwg D3391 Rev: J

140 - ***INSPECT INSIDE BORE***

150 - 1-Drill (PILOT HOLE) aft cap holes per Dwg D3391 using DT8803

160 - Form as per Dwg D3391 Using Bend Prog 3391025 4.275

180 - 1-Open Aft cap pilot hole to .208" as per Dwg D3391 2-Drill float bag holes using DT8809 as per Dwg D3391(Holes marked "A" Only. 3-Drill wearplate holes as per Dwg D3391 using DT8878(Mid Tube) & DT8217 Wearplate Jig . *****Do Not Open To Finished Size***** 4-Drill Wearshoe holes as per DWG D3391 using DT8939 locating from 2 previously drilled aft wearplate holes. 5-Open wearplate holes to 0.297" and c'bore as per dwg D3391 6-Open up all float bag holes to 0.328" and c'sink as per Dwg D3391. 8- Scribe batch # on fwd end

DART
AEROSPACE
S008535

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CANADA
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www.dartaerospace.com



Aft Tube Assembly

PART NO: D3391-025

Revision:

Operation:

Change No:

Start up Operation

Mfg Date: 11/09/17

Job No: 167283-E

220 - 1- Instal spacers as per dwg D3391 A/R Magnabond 6398 Batch: M137712 exp. date: 2018/01 cure time 12hrs as per QSI0015 2- Grind crossbolts flush 3- Back drill using #9 drill 4- Touchup Magnabond 5- Debur

235 - AND REALODINE AS PER PAR09-043

240 - PRIME AS PER DWG AND QSI005 4.2.1.3.3

260 - 1-Install inserts as per Dwg D3391 2-Install Aft Cap as per Dwg D3391 A/ R Sikaflex-241/-291 M13864

Sikaflex expiry date: 18/02 3- INSTALL WEARPLATES AS PER DWG

290 - 5- Detail DD, open (5) forward wearplate holes 0.375", then use DT10247 and drill holes for nutplates and c'sink.

6-Open wearplate holes to 0.297" and c'bore as per dwg D3391. ***SIX FARTHEST AFT HOLES ONLY*** 7-Open up all float bag holes to 0.328" and c'sink as per Dwg D3391. 8-Debur 9- Scribe batch # on fwd end

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D6014-090	1	42	0	0
220-Skidtubes	D3670-4-200 <u>M165393</u>	4	79	0	0
260-HandFinish	ALS4-1032-130 <u>5007279</u>	8	1,343	0	0
	D4095-047 <u>F164735</u>	1	20	0	0
	D4095-049	1	18	0	0
	MS20601-AD4W3 <u>5016824</u>	12	150	0	0
	MS20601-AD4W7 <u>M137148</u>	8	313	0	0
	MS21075L5 <u>Fm138047</u>	10	173	0	0
270-QC	ALS4-1032-225 <u>508959</u>	4	897	0	0
	AN3C4A <u>5000533</u>	6	1,670	0	0
	AN3C5A <u>5014396</u>	4	364	0	0
	D2646 <u>F164005</u>	1	151	0	0
	D3672-1 <u>F150071</u>	2	1,777	0	0
	NAS1149C0332R	10	4,758	0	0

Part Specifications

Specifications could not be found.

Plex 10/27/17 1:53 PM dart.Michaud-Febrille.Victoria

OP100 D6014-090 BL394127

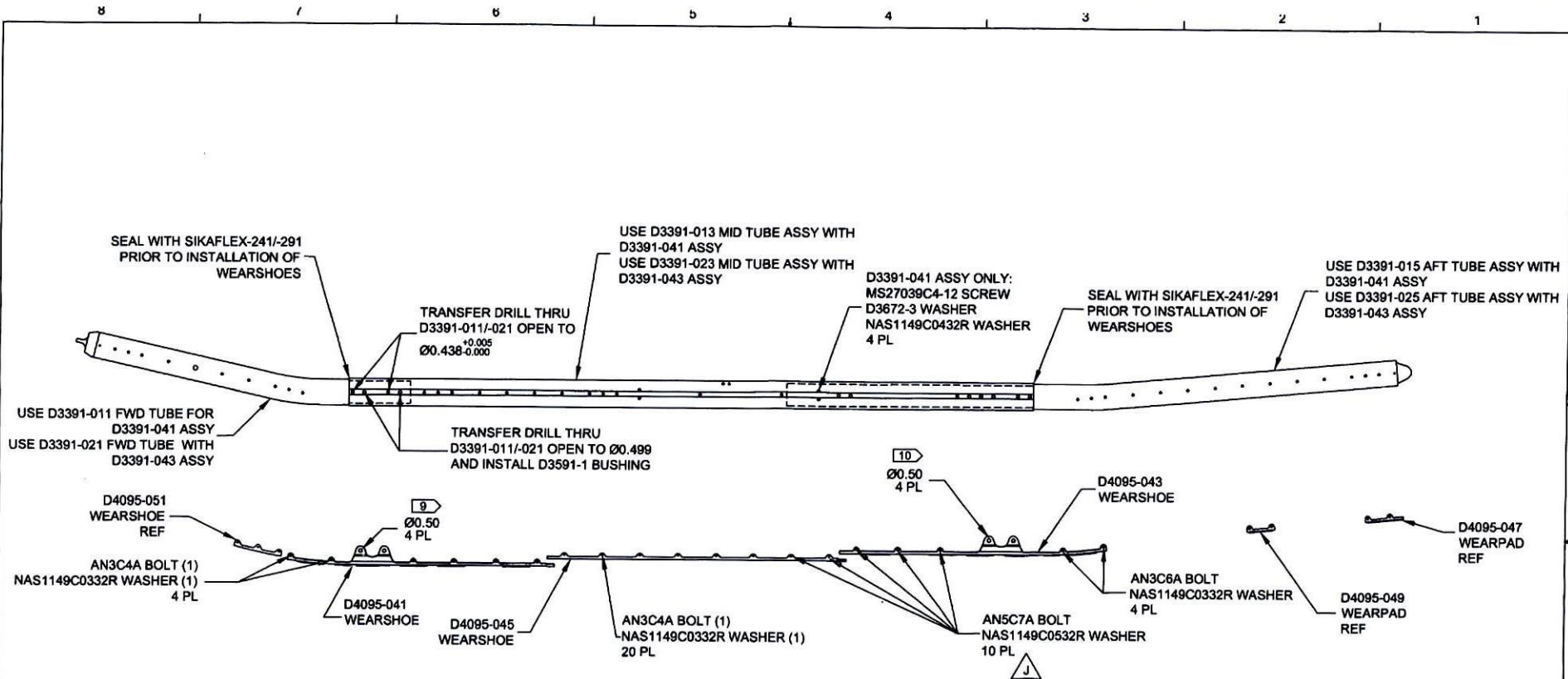
D3391-041/-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY -041	QTY -043	PART NUMBER	DESCRIPTION
X		D3391-041	FLOAT SKIDTUBE ASSEMBLY
	X	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1		D3391-011	FWD TUBE ASSEMBLY
1		D3391-013	MID TUBE ASSEMBLY
1		D3391-015	AFT TUBE ASSEMBLY
	1	D3391-021	FWD TUBE ASSEMBLY
	1	D3391-023	MID TUBE ASSEMBLY
	1	D3391-025	AFT TUBE ASSEMBLY
2	2	D3591-1	BUSHING
4		D3672-3	WASHER
1	1	D4095-041	WEARSHOE
1	1	D4095-043	WEARSHOE
1	1	D4095-045	WEARSHOE
1	1	D4095-047	WEARPAD
1	1	D4095-049	WEARPAD
1	1	D4095-051	WEARSHOE
24	24	AN3C4A	BOLT
4	4	AN3C6A	BOLT
10	10	AN5C7A	BOLT
28	28	NAS1149C0332R	WASHER
10	10	NAS1149C0532R	WASHER
4		MS27039C4-12	SCREW
4		NAS1149C0432R	WASHER

J

J	INCORPORATED DSI 9733, REFORMAT DRAWING CHANGED CBORE DEPTH (ZN D2-8, D2-9), REVISED TABLES, REPLACED POWDER COAT WITH PAINT	ML	16.01.14
I	REMOVE GASKETS AND REPLACE ALL WEARSHOES; PARTS LIST UPDATE, ZN A8-1, ZN A8-2, ZN A6-4, ZN B6-8; LPS-3 COATING REMOVED FROM NOTE 2, ZN A3-1, ZN A3-2, REMOVED INSERT AELS-1032-130, ZN B6-4, B2-4, C7-8, C3-8; REMOVED HOLES, ZN D6-4 ZN D2-4, ZN D7-8, ZN D3-8	XDF	11.10.13
H	DRAWING UPDATED TO CURRENT STANDARDS. SHT 1 PL. ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. SHT 2 PL. ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. (FOR FURTHER INFO SEE DSI 9364 & NCR 08-074)	AJS	08.08.20
G	REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS, DWG REORGANIZED FOR CLARITY	DC	07.07.31
F	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021	PH	07.01.18
E	CHANGE TOLERANCE, EASE MANUFACTURE	PH	06.04.25
D	UPDATE TOLERANCE, CHANGE HOLE SIZE	PH	06.01.23
C	LENGTHEN AFT EXTENSION	PH	05.09.27
B	DRAWING UPDATES	PH	05.06.10
A	NEW ISSUE	PH	05.02.07
REV	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC EUGENE, OR	
DRAWN	ML		
CHECKED	CP	DRAWING NO.	REV. J
MFG. APPR.	DP	D3391	SHEET 1 OF 11
APPROVED	DP	TITLE	SCALE
DE APPR.	DP	412 FLOAT SKIDTUBE	NTS
DATE	16.01.14	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

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2016-04-28
EAC 16-96



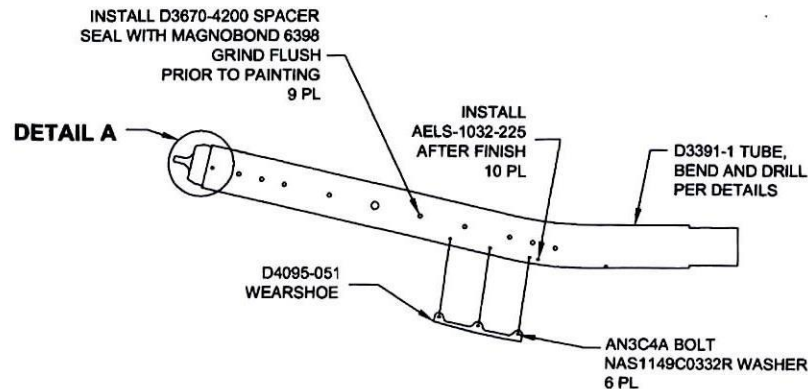
D3391-041/-043 ASSY

NOTES:

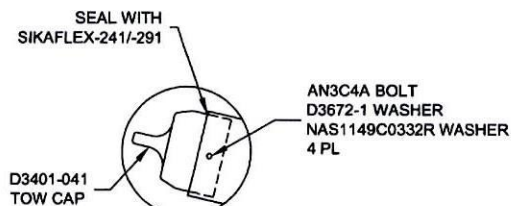
- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME PER DART QSI 005 4.2.1.3.3
PAINT WHITE PER DART QSI 005 4.2.2.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.6
- 7) WEIGHT: N/A
- 8) COAT ALL EXPOSED FASTENERS WITH LPS "LPS PROCYON"
- 9) FIT D4095-041 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH THE APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-041
- 10) FIT D4095-043 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH THE APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-043

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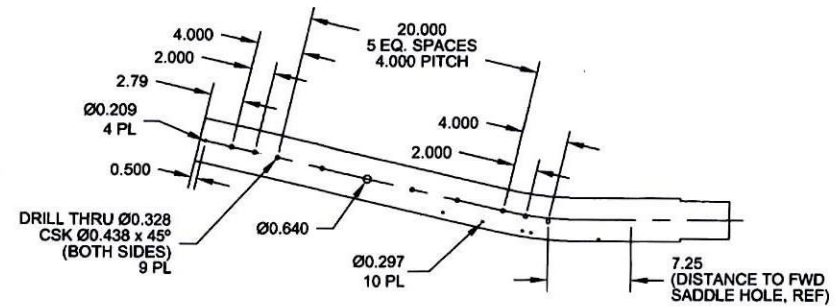
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CHECKED	CP	DRAWING NO.	REV. J
MFG. APPR.	DP	D3391	SHEET 2 OF 11
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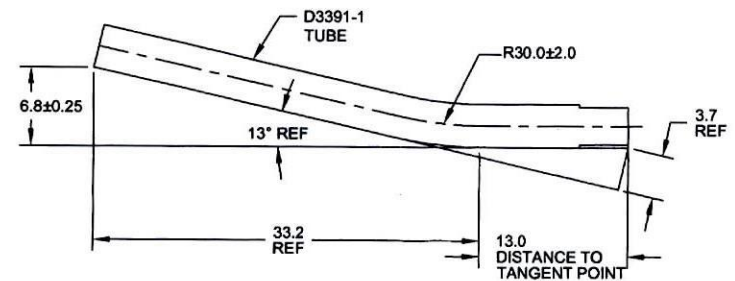
D3391-011 FWD TUBE ASSEMBLY
ASSEMBLY DETAIL



DETAIL A
SCALE 2X



D3391-011 DRILLING DETAIL



D3391-011 BENDING DETAIL
(MAKE FROM D3391-1)

D3391-011 FWD TUBE ASSEMBLY PARTS LIST

QTY -011	PART NUMBER	DESCRIPTION
X	D3391-011	FWD TUBE ASSEMBLY
1	D3391-1	TUBE
1	D3401-041	TOW CAP
9	D3670-4200	SPACER
4	D3672-1	WASHER
1	D4095-051	WEARSHOE
10	AELS-1032-225	INSERT
10	AN3C4A	BOLT
10	NAS1149C0332R	WASHER

DESIGN	PH	DART AEROSPACE USA, INC	
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CHECKED	CP	DRAWING NO.	REV. J
MFG. APPR.	<i>PC</i>	D3391	SHEET 3 OF 11
APPROVED	<i>ML</i>	TITLE	SCALE
DE APPR.	<i>ML</i>	412 FLOAT SKIDTUBE	NTS
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INSTALL D3670-4200 SPACER
SEAL WITH MAGNOBOND 6398
GRIND FLUSH
PRIOR TO PAINTING
4 PL

DETAIL B

D4095-051
WEARSHOE

INSTALL
AELS-1032-225
AFTER FINISH
10 PL

AN3C4A BOLT
NAS1149C0332R WASHER
6 PL

D3391-021 FWD TUBE ASSEMBLY ASSEMBLY DETAIL

SEAL WITH
SIKAFLEX-241/-291

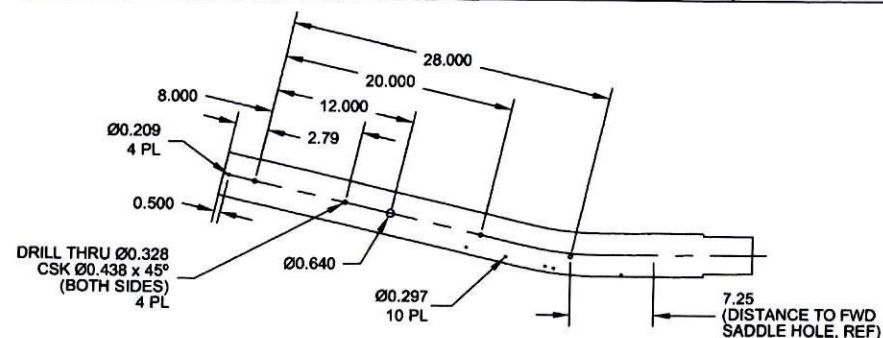
D3401-041
TOW CAP

AN3C4A BOLT
D3672-1 WASHER
NAS1149C0332R WASHER
4 PL

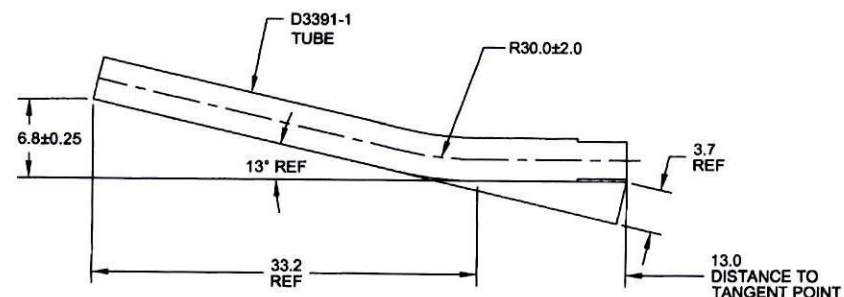
DETAIL B SCALE 2X

D3391-021 FWD TUBE ASSEMBLY PARTS LIST

QTY -021	PART NUMBER	DESCRIPTION
X	D3391-021	FWD TUBE ASSEMBLY
1	D3391-1	TUBE
1	D3401-041	TOW CAP
4	D3670-4200	SPACER
4	D3672-1	WASHER
1	D4095-051	WEARSHOE
10	AELS-1032-225	INSERT
10	AN3C4A	BOLT
10	NAS1149C0332R	WASHER



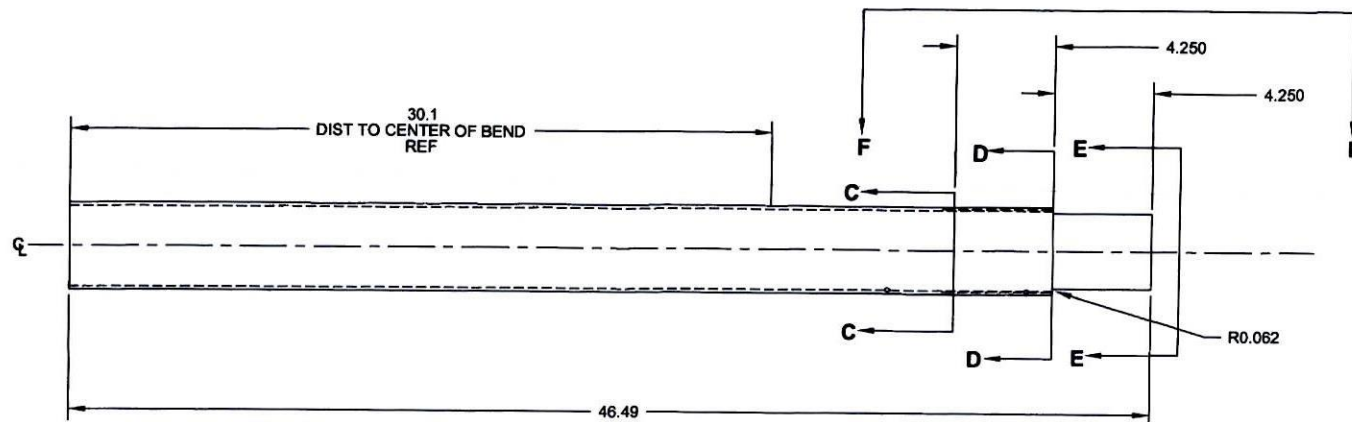
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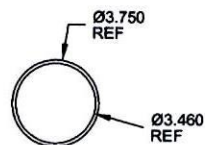
D3391-021 BENDING DETAIL (MAKE FROM D3391-1)

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2016-04-28

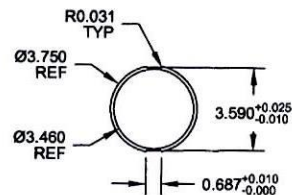
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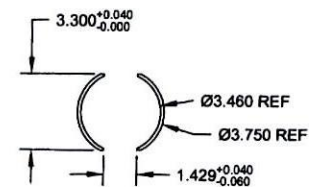
D3391-1 TUBE
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



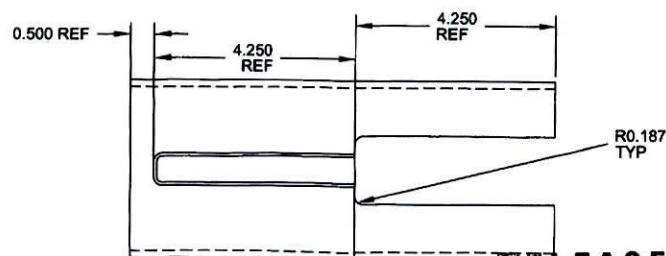
SECTION C-C



SECTION D-D



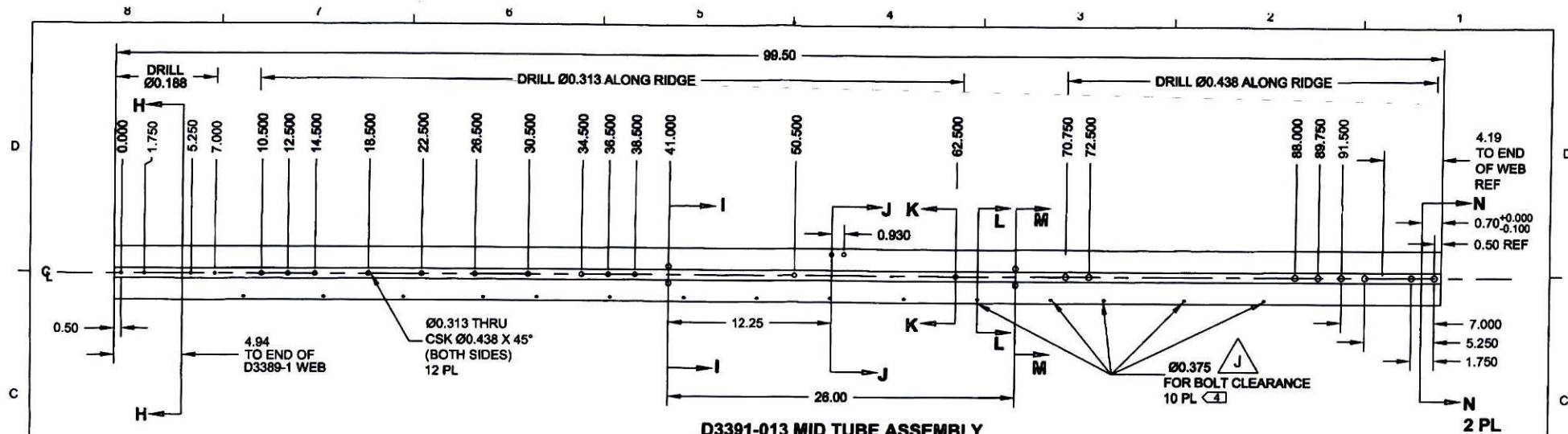
SECTION E-E



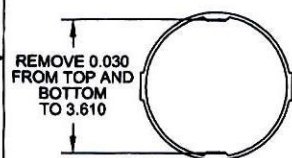
VIEW F-F
SCALE 2X

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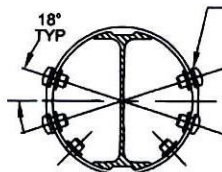
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D3391-013 MID TUBE ASSEMBLY

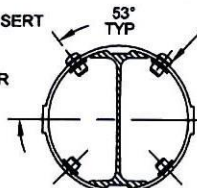


SECTION H-H
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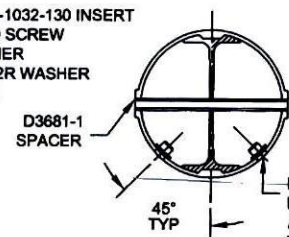
SECTION I-I
SCALE 2X

DRILL Ø0.391
INSTALL ALS4-428-165 INSERT
MS27039C4-08 SCREW
D3672-3 WASHER
NAS1149C0432R WASHER
AFTER FINISH
4 PL



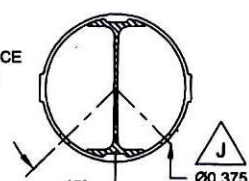
SECTION J-J
SCALE 2X

DRILL Ø0.297
INSTALL AELS-1032-130 INSERT
MS27039C1-08 SCREW
D3672-1 WASHER
NAS1149C0332R WASHER
AFTER FINISH
4 PL



SECTION K-K
SCALE 2X

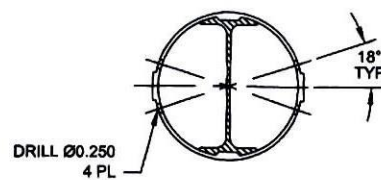
WELD INTO PLACE
& GRIND FLUSH
(BOTH ENDS)
12 PL



SECTION L-L
SCALE 2X

D3391-013 MID TUBE ASSEMBLY PARTS LIST

QTY -013	PART NUMBER	DESCRIPTION
X	D3391-013	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
4	D3672-1	WASHER
4	D3672-3	WASHER
12	D3681-1	SPACER
24	AELS-1032-130	INSERT
4	ALS4-428-165	INSERT
4	MS27039C1-09	SCREW
4	MS27039C4-08	SCREW
4	NAS1149C0332R	WASHER
4	NAS1149C0432R	WASHER

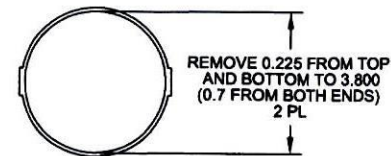


SECTION M-M
SCALE 2X



D3391-013 MID TUBE ASSEMBLY

- 1) MATERIAL: MAKE FROM D2500-1-100
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-2411-291 PER QSI 015
- 3) WELDING: PER DART QSI 004
- 4) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 AND Ø0.375 HOLES FOR WEARSHOE INSERTS AND NUTPLATES, CBORE AS NOTED AND INSTALL INSERT/NUTPLATES EXCEPT WHERE INDICATED.



SECTION N-N
SCALE 2X

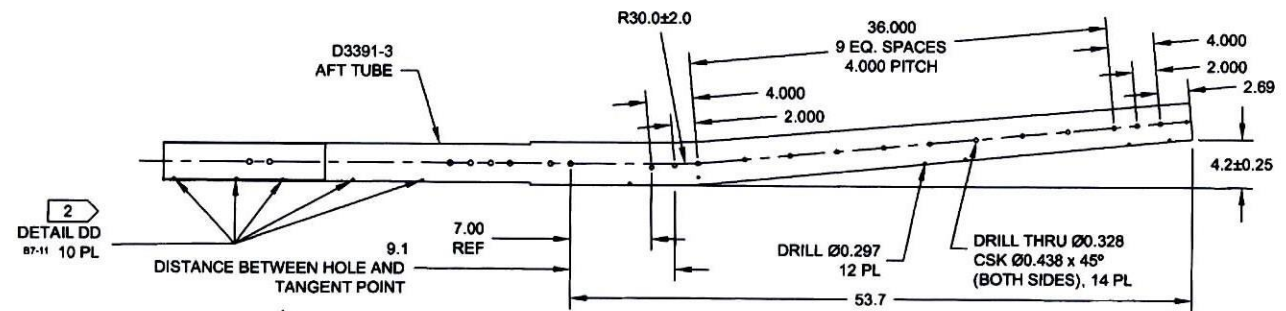
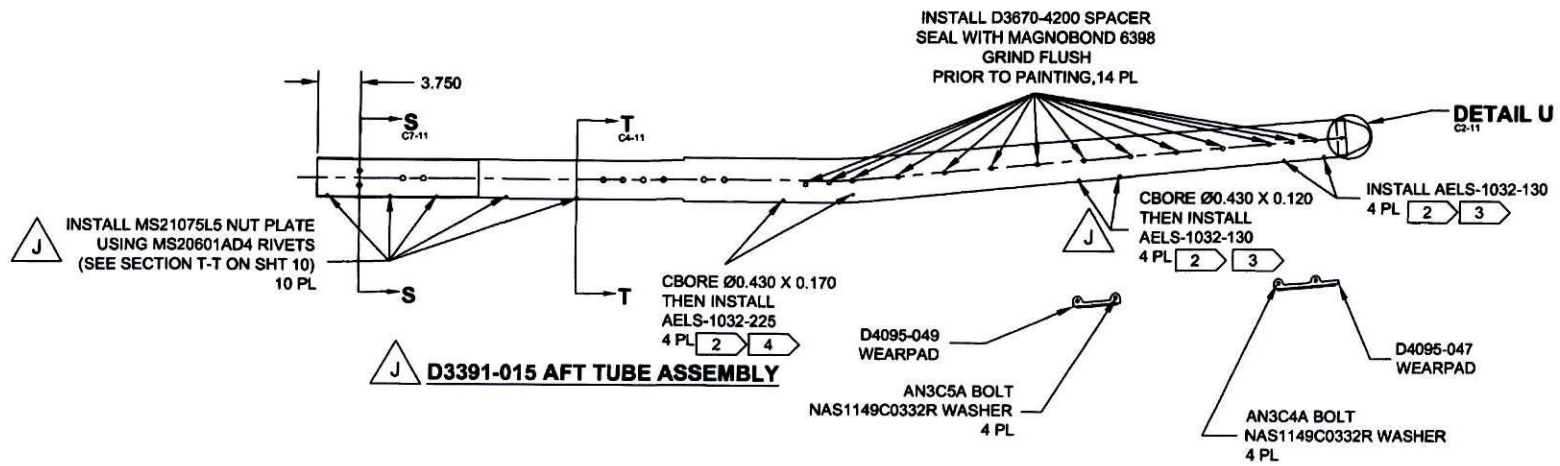
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DRAWN	ML
CHECKED	CP
MFG. APPR.	CP
APPROVED	CP
DE APPR.	CP
DATE	16.01.14

DART AEROSPACE USA, INC

EUGENE, OR	REV. J
DRAWING NO.	SHEET 6 OF 11
D3391	SCALE
412 FLOAT SKIDTUBE	NTS

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D3391-015 AFT TUBE ASSEMBLY PARTS LIST

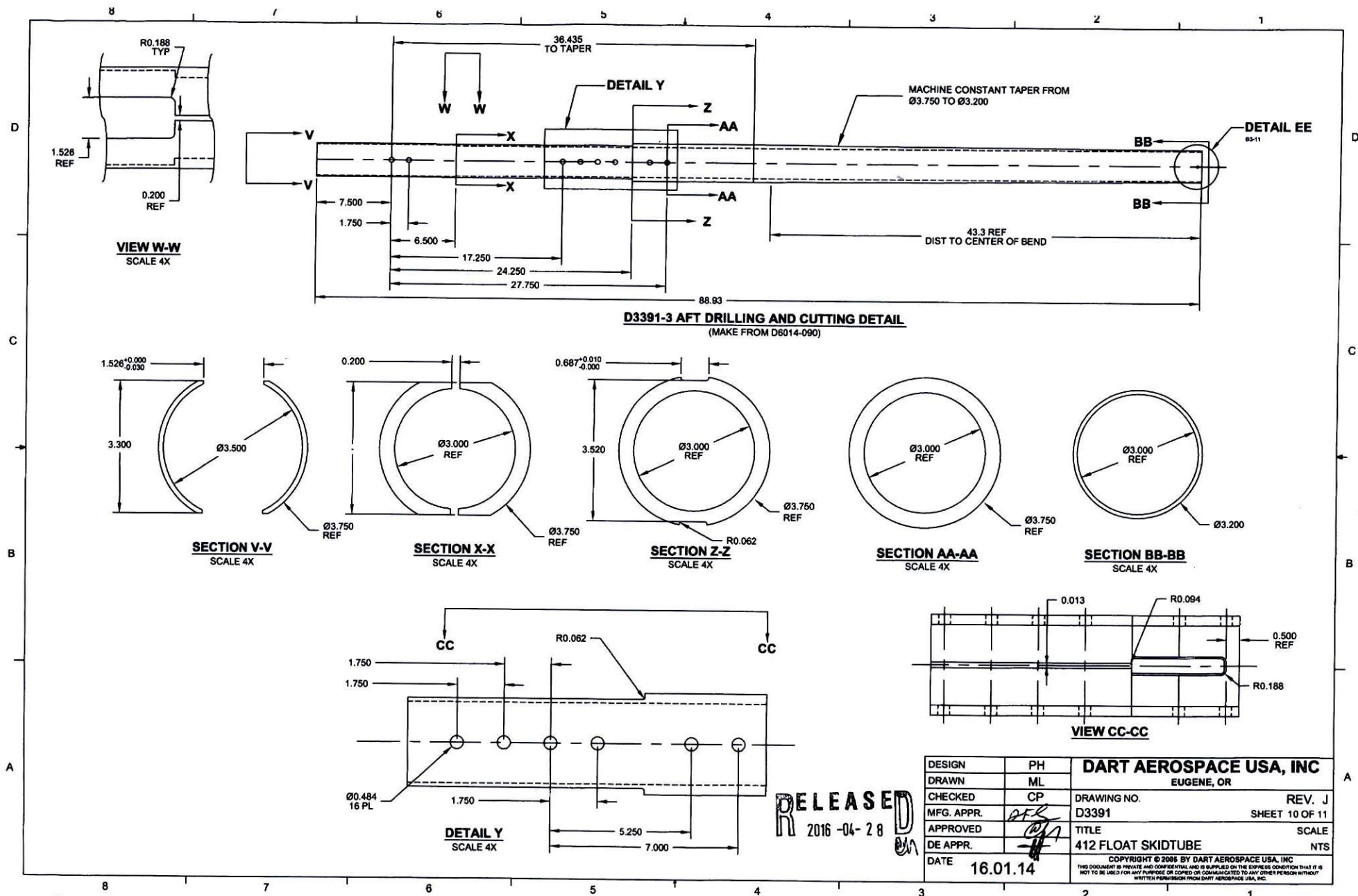
QTY	PART NUMBER	DESCRIPTION
1	D3391-015	AFT TUBE ASSEMBLY
1	D2646	AFT CAP
1	D3391-3	AFT TUBE
14	D3670-4200	SPACER
2	D3672-1	WASHER
1	D4095-049	WEARPAD
1	D4095-047	WEARPAD
8	AELS-1032-130	INSERT
4	AELS-1032-225	INSERT
4	AL54-428-165	INSERT
6	AN3C4A	BOLT
4	AN3C5A	BOLT
20	MS20601AD4	RIVET, BLIND
10	MS21075L5	NUT PLATE, FLOATING
10	NAS1149C0332R	WASHER

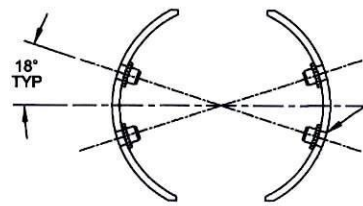
NOTES:

- 1) COAT ALL EXPOSED FASTENERS WITH LPS "LPS PROCYON"
- 2) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 AND Ø0.375 HOLES FOR WEARSHOE INSERTS AND NUTPLATES. C'BORE AS NOTED AND INSTALL INSERT/NUTPLATES EXCEPT WHERE INDICATED.
- 3) ENSURE WALL THICKNESS IS BETWEEN 0.070 AND 0.130 BEFORE INSTALLING INSERT
- 4) ENSURE WALL THICKNESS IS BETWEEN 0.130 AND 0.225 BEFORE INSTALLING INSERT

RELEASED
2016-04-28

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	ML	EUGENE, OR	
CHECKED	CP	DRAWING NO.	REV. J
MFG. APPR.	<i>Se</i>	D3391	SHEET 8 OF 11
APPROVED	<i>Ben</i>	TITLE	SCALE
DE APPR.	<i>#</i>	412 FLOAT SKIDTUBE	NTS
DATE	16.01.14	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC	
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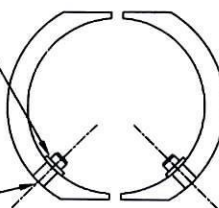


SECTION S-S DS-8.9
SCALE 5X

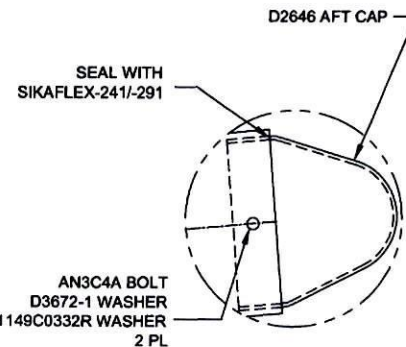
DRILL $\varnothing 0.391$
CBORE $\varnothing 0.516 \times 0.040$ DEEP
INSTALL ALS4-428-165 INSERT
4 PL

USE DT8217 DRILL TEMPLATE
TO LOCATE HOLES AND OPEN
TO $\varnothing 0.375$

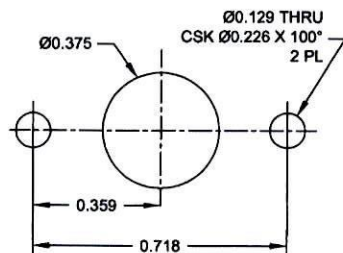
MS21075L5 NUTPLATE
REF



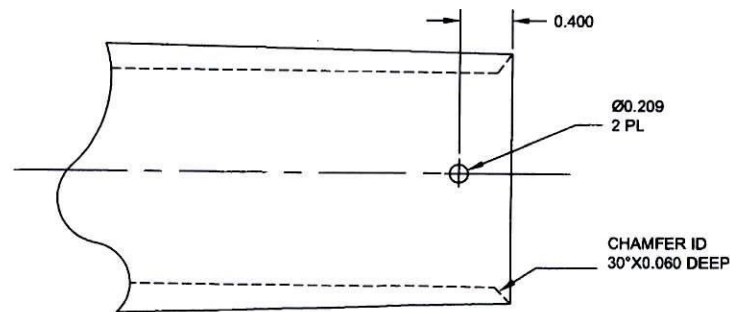
SECTION T-T DS-8.9
SCALE 5X
5 PL



DETAIL U D1-8.9
SCALE 5X



DRILLING DETAIL DD
SCALE 10X
87-8.9



DETAIL EE
SCALE 2X
D1-11

NOTES:
1) USE INDUSTRY STANDARD NUT PLATE DRILL JIG IF REQUIRED.

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2016-04-28

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	ML	EUGENE, OR	
CHECKED	CP	DRAWING NO.	REV.
MFG. APPR.		D3391	SHEET 11 OF 1
APPROVED		TITLE	SCALE
DE APPR.		AFT TUBE ASSEMBLY	NT
DATE	16.01.14	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC	
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DART AEROSPACE LTD		Work Order: 167 283-E
Description: Float Skidtube (412)		Part Number: D3391-3
Inspection Dwg: D3391	Rev: J	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Lathe Section						
14.000	+/-0.010	14.0	✓		TAPE	
3.500	+/-0.010	3.503	✓		VERNO8	
Ø3.200	+/-0.010	3.1985	✓			
Ø3.750	+/-0.010	3.748	✓		↓	
30° x 0.060 chamfer	+/-0.010	.070	✓		VERNO8	
88.93	+/-0.030	88.925	✓		TAPE	

Measured by: PMP	Date: 2017-11-06
Audited by: AD	Date: 12-11-13

HAAS Section						
1.526	+0.000/-0.030	1.510	✓		Kt-05	verm.
7.500	+/-0.010	7.500	✓		" "	" "
27.750	+/-0.010	27.750	✓		TAPE	—
31.750	+/-0.010	31.750	✓		" "	" "
35.250	+/-0.010	35.250	✓		" "	" "
3.300	+/-0.010	3.300	✓		Kt-05	verm.
0.200	+/-0.010	0.200	✓		" "	" "
3.520	+/-0.010	3.520	✓		AG-10	micro
0.687	+0.010/-0.000	0.689	✓		Kt-05	verm.
R0.062	+/-0.010	0.0625	✓		R-G	—
Ø0.484	+0.005/-0.001	0.486	✓		Kt-05	verm.

Measured by: DAS 1	Date: 17-12-04
Audited by: 9-89 JKL	Date: 17/12/04

Rev	Date	Change	Revised by	Approved
A	06.04.24	New Issue P/O D3391-015/-025	KJ/JLM	
B	06.06.19	Dwg revision update	KJ/JLM	
C	07.04.20	Ø0.208 dimension removed	KJ/JLM	
D	07.09.06	0.400 dimension removed	KJ/JLM	
E	07.11.23	Dwg Rev. updated	KJ/EC/DD	
F	09.04.27	Dimensions updated per Rev H and NCR09-028	KJ/JLM	
G	09.11.16	Dimension 0.200 removed	KJ	
H	11.06.21	Dimension 44.995 removed	KJ	
I	12.05.15	Dwg Rev updated	KJ	
J	12.05.23	Dimension updated	KJ	
K	12.10.15	88.93 dimension removed	KJ	
L	12.11.28	88.93 dimension added	KJ	
M	16.06.23	Dimensions updated per Rev J	KJ	

